

Date: Friday, 10/10/2008 12:57:28 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L AFT X-TUBE
Job Number	: 42540		
Estimate Number	: 13222		
P.O. Number	:	Part Number	: D206667203TRN
This Issue	: 10/10/2008 S.O. No. :	Drawing Number	: D206-667-243 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : CROSSTUBES	Drawing Revision	: B
Previous Run	: 42304	Material	:
Written By	:	Due Date	: 17/10/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUL 08.10.10</u>		
Comment	: Est Rev:A 08-03-06 new issue DD verified by:ec Est Rev B 08.04.02 Removed polish EC verified by: DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6004115	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D6004-115	Crosstube	B34685

Check OD = 2.500"; ID = 1.800"

a.m 08.10.2011

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-File down transition lines smooth.

a.m 08.10.2011

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

a.m 08.10.2011

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-File down transition lines smooth.

3-Remove sand and plugs

a.m 08.10.2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 10/10/2008 12:57:28 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 42540

Part Number: D206667203TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Qm 08-10-2008

6.0 QC8

SECOND CHECK



AWM 7-10-21



Comment: SECOND CHECK

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-10-23



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Qm 08-10-23

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in kanban rack

Location: X-TUBE CELL

AWM

8-10-23

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23

Job Completion



mf 08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42540
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b> D206-667-243
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	/		
	2.018	+0.005/-0.000	2.023	/		
	2.079	+0.005/-0.000	2.084	/		
	2.145	+0.005/-0.000	2.150	/		
	2.209	+0.005/-0.000	2.213	/		
	2.287	+0.005/-0.000	2.290	/		
	2.363	+0.005/-0.000	2.367	/		
	2.433	+0.005/-0.000	2.436	/		
	0.200	+/-0.010	0.200	/		
	0.500 x 30°	+/-0.010	0.500x30°	/		
	R0.063	+/-0.010	R0.063	/		
	R0.500	+/-0.010	R0.500	/		
	4.438	+/-0.030	4.438	/		
SIDE B	104.91	+/-0.020	104.910	/		
	2.490	+0.005/-0.000	2.495	/		
	2.018	+0.005/-0.000	2.023	/		
	2.079	+0.005/-0.000	2.084	/		
	2.145	+0.005/-0.000	2.150	/		
	2.209	+0.005/-0.000	2.213	/		
	2.287	+0.005/-0.000	2.290	/		
	2.363	+0.005/-0.000	2.367	/		
	2.433	+0.005/-0.000	2.436	/		
	0.200	+/-0.010	0.200	/		
	0.500 x 30°	+/-0.010	0.500x30°	/		
	R0.063	+/-0.010	R0.063	/		
	R0.500	+/-0.010	R0.500	/		
	4.438	+/-0.030	4.438	/		

<b>Measured by:</b> a.m.	<b>Audited by:</b> AHM	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08.10.20	<b>Date:</b> 8-10-21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05-07-26-#**UNDER REVIEW**  
06.08.10 RH  
Redrawn Detail F  
RH 08.10.14

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

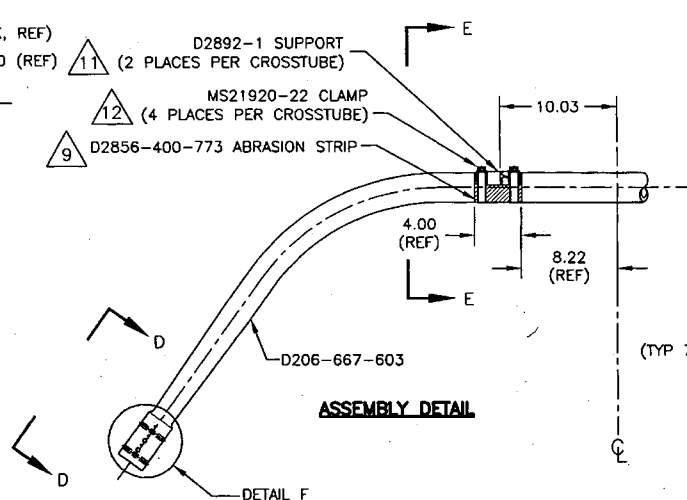
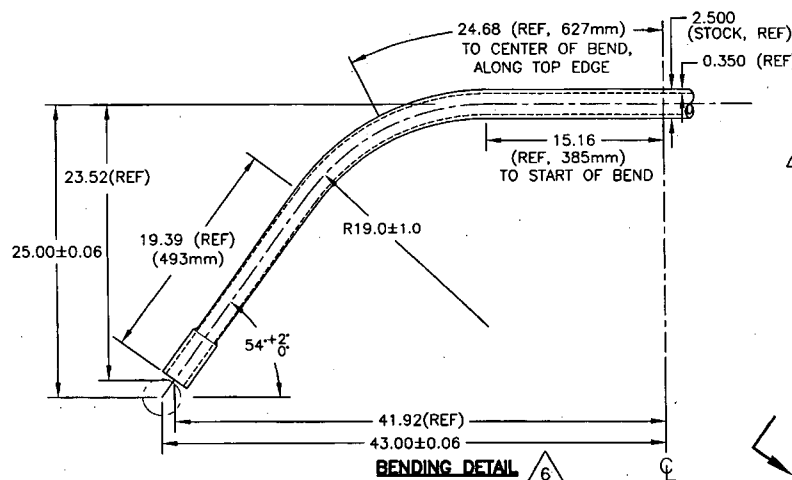
**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH =  $104.91 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

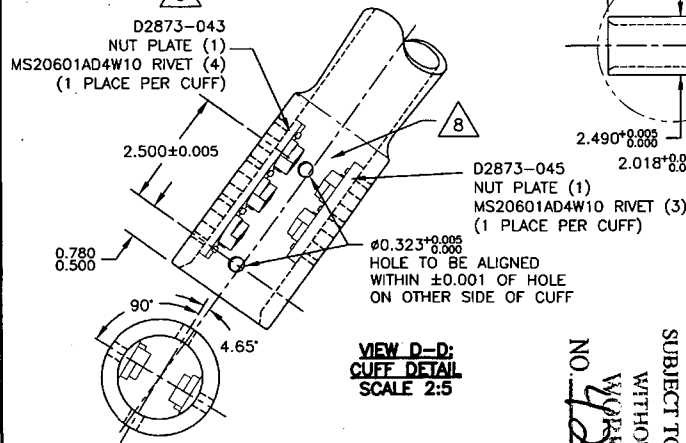
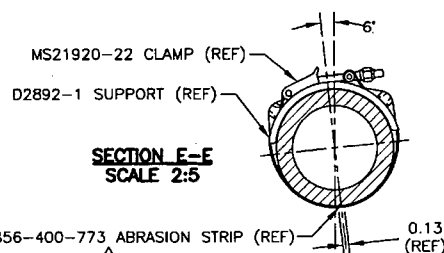
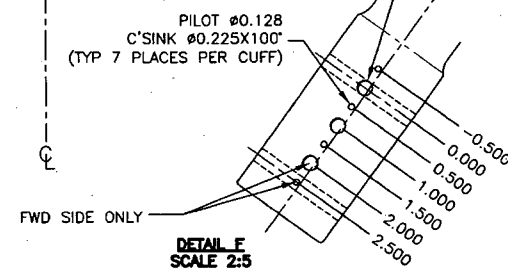
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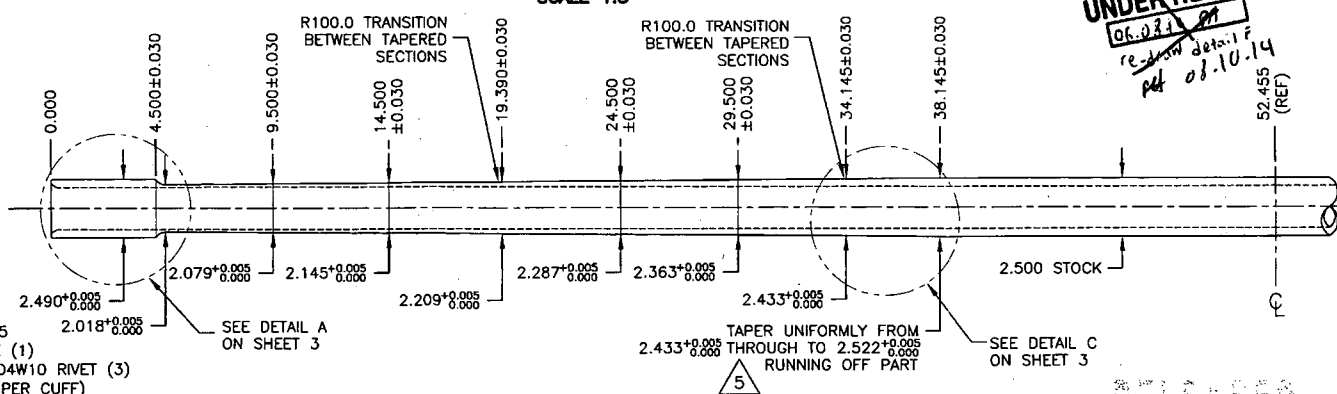
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**B**  $\varnothing 0.323^{+0.005}_{-0.000}$   
(TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN  $\pm 0.001$   
OF HOLE ON OTHER SIDE OF CUFF



**TURNING DETAIL SCALE 1:5**

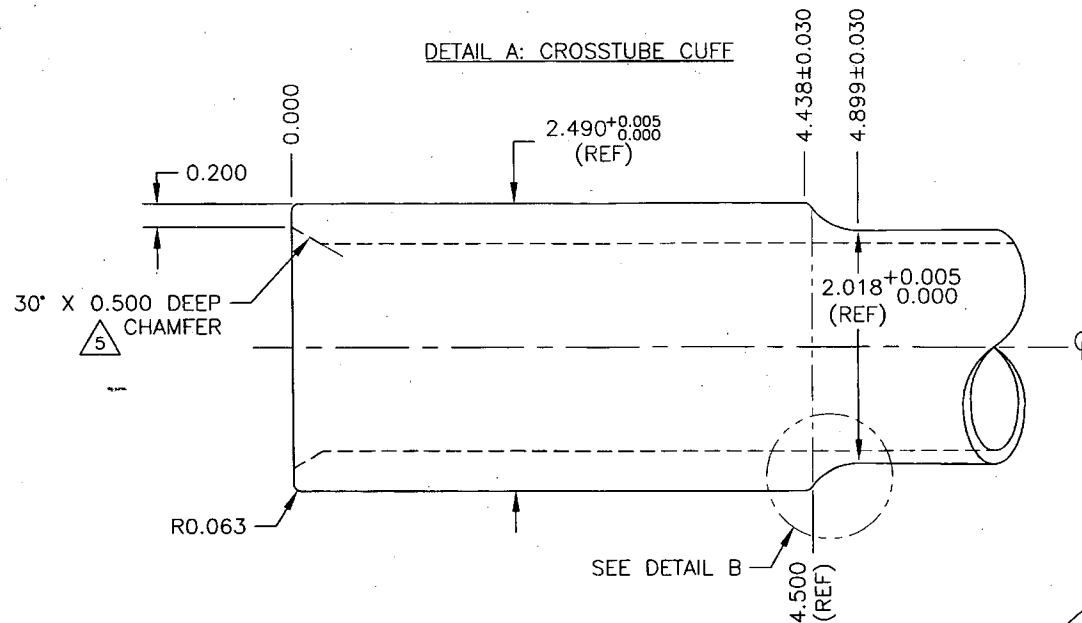


**UNDER REVIEW**  
06.08.11  
re-review detail F  
pt 08.10.14

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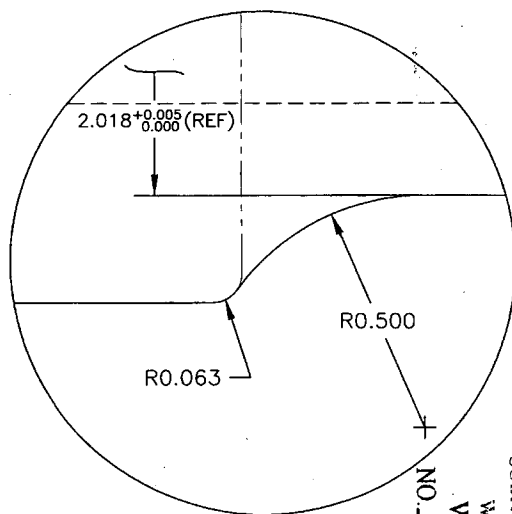
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	REV. B
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)		SCALE 1:10	

# DETAIL A: CROSSTUBE CUFF



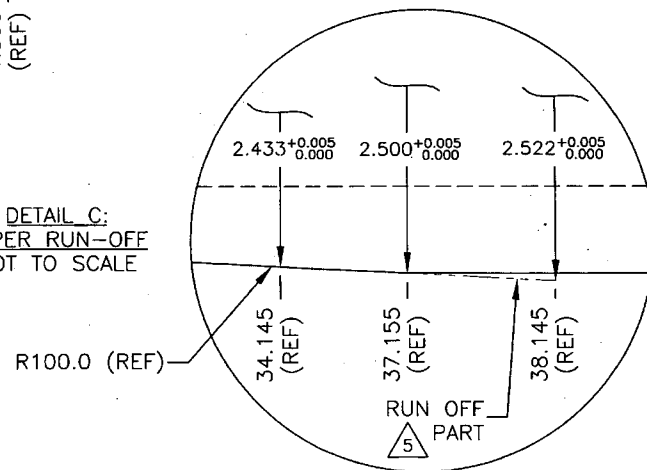
05.07.26

UNDER REVIEW  
06.03.10 AH  
re-drawn Detail F  
08.10.14



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26	SCALE 1:1	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	